

Date: Monday, 1/14/2008 2:37:35 PM
 By: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR WEDGE
Job Number	: 36753		
Estimate Number	: 12110		
P.O. Number	:	Part Number	: D32001
This Issue	: 1/14/2008 S.O. No. :	Drawing Number	: D3200 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 32472	Material	:
Written By	:	Due Date	: 2/5/2008 Qty: 40 Um: Each
Checked & Approved By	: <u>08 01 15</u>		
Comment	: Est Rev: A Removed from 9 Digit 06-01-25 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 0.0525 sf(s)/Unit Total : 2.1000 sf(s)

UHMW 1" Black

Material: Black UHMW 0.95" or 1.00" thick

Use bearpaw scrap material

(MUHMWB10)

Identify for D3200-1

Batch: M106161

J.L 08/02/06

(40)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank: 2.700" x 2.700

J.L 08/02/06

(40)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3200-1 as per Folio FA337 and Dwg D3200

2-Deburr

J.L 08/02/07

(40)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/02/07

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/02/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:37:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR WEDGE

Job Number: 36753

Part Number: D32001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BG 08-02-07 (40)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 76

8/2/8

SCP

(40)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 08/02/08

Job Completion



min 2008/2/08

(40)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	<u>36753</u>
Description: Door Post Block		Part Number:	D3200-1
Inspection Dwg: D3200 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.196	+0.005 -0.000	.196	✓			
0.405 x 100°	+/-0.010	.403	✓			
R0.100	+/-0.010	.100	✓			
R0.130	+/-0.010	.130	✓			
1.630	+/-0.005	1.630	✓			
0.440	+/-0.030	.333	✓			
2.500	+/-0.010	2.500	✓			
1.845	+/-0.010	1.845	✓			
0.015 = 0.050	N/A	.025	✓			
1.000	+/-0.010	1.000	✓			
1.620	+/-0.005	1.621	✓			
2.500	+/-0.030	2.501	✓			
0.750	+/-0.030	.753	✓			

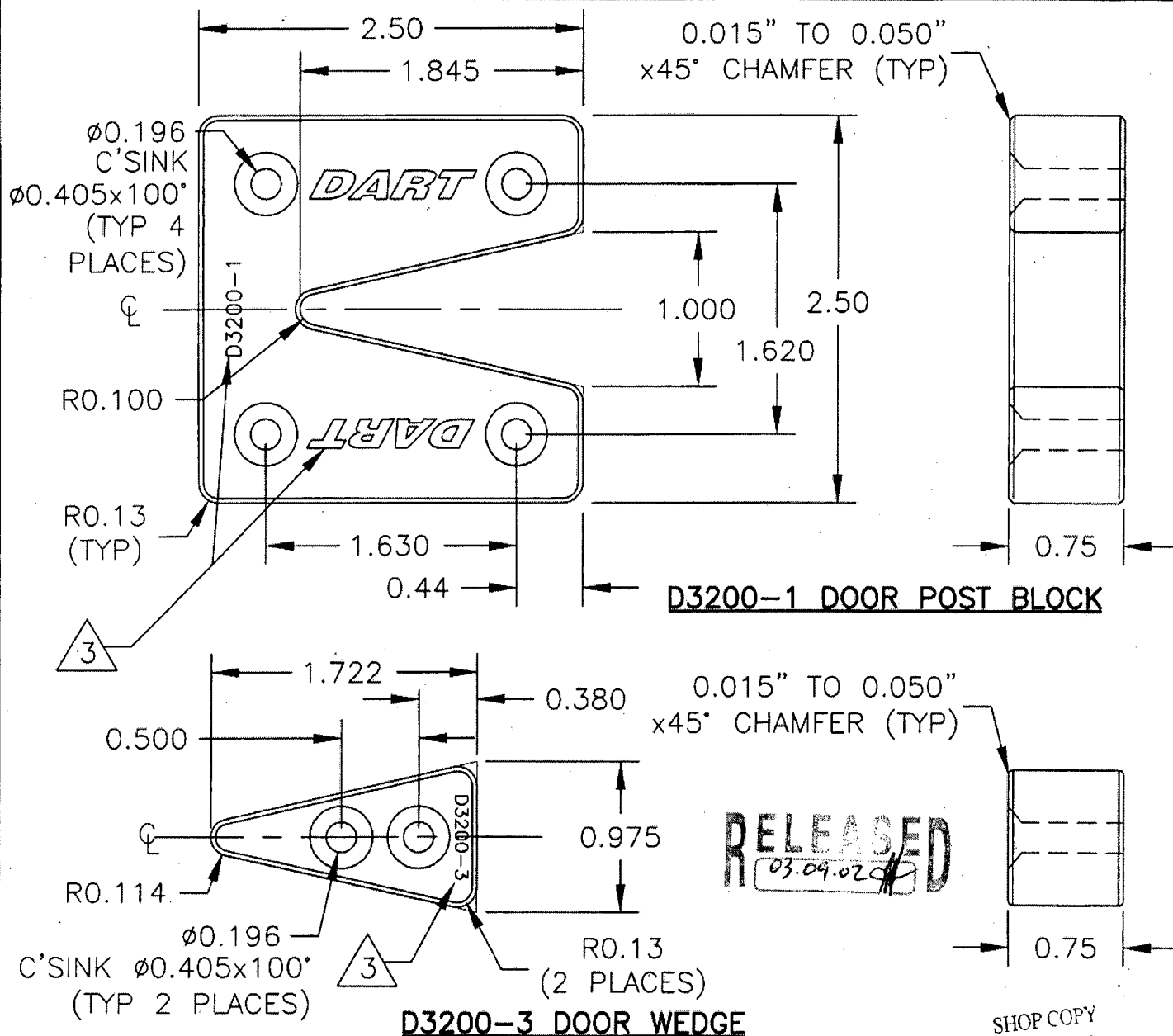
Measured by:	<u>JL</u>	Audited by:	<u>RF</u>	Prototype Approval:	N/A
Date:	<u>08/02/06</u>	Date:	<u>08.02.06</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D412-698-015	KJ/RF <u>RF</u>	<u>RF</u>



DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3200	REV. A SHEET 1 OF 1
DATE 03.08.06		TITLE DOOR WEDGE	SCALE 1:1
A	03.08.06	NEW ISSUE	



D3200-1/-3

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36753

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